

3031

Work Order ID 68813

Thursday, April 21, 2011 10:37:51 AM

Page 1

Item ID: D3954-1

Revision ID:

Item Name: GWT Pin

Start Date: 4/26/2011 Start Qty: 10.00

Required Date: 5/6/2011 Req'd Qty: 10.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan: MF

Date: 11-04-21 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3954

B

100



Doosan

Doosan Lathe

Cobra

Memo

1-Turn as per folio FA824 & dwg D3954

FOLIO REV: 1/1/11

DWG REV: 13

2-Deburr as required

0.00

0.00

0.00

0.00

110



QC

Quality Control

Memo

QC2- Inspect parts off machine FA1/FA1B

11 11/5/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68813

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Page 2

Item ID: D3954-1

Accept



Setup Start



Revision ID:

Stop



Item Name: GWT Pin

Start Date: 4/26/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

Quality Control

135 Powdercoat

Spray Painting per QSI005 4.2

0.00



Spray Paint

Memo

Spray Painting

1- MASK THREADS PRIOR TO PAINTING AS PER DWG

0.00

2- SPRAY PAINT YELLOW AS PER DWG
A/R BATCH: N/A

Start Time: 1:00
over Temp: 400 °F
Finish Time: 1:30

3X Ø M-1 11/05/30

140

QC14- Inspect Spray Paint

0.00



QC

Memo

Quality Control

QC3

0.00

P107

Dart Aerospace Ltd

W/O: 68813		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/5/30	140	Perm. change change to QC3 inspection	(3X) BP 11/5/30	[Signature]			[Signature] 11/5/30	

Part No: D3954-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 68813

Thursday, April 21, 2011 10:37:51 AM

Page 3

Item ID: D3954-1

Accept

Setup Start

Revision ID:

Stop

Item Name: GWT Pin

Start Date: 4/26/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



14/01/30 (3)

11/5/31

H11-05-30
(3)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 10:37:48 AM

Page 1

Work Order ID: 68813



Parent Item: D3954-1



Parent Item Name: GWT Pin

Start Date: 4/26/2011

Required Date: 5/6/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303R1.000

Purchased

No

100

f

10.1470

0.24

2.4



303 Round Bar 1.00

Location

Loc Qty

Loc Code

MAT028

10.147

116700

10.147

113598

0.24 PL

~~0.67 PL~~ 0.67 PL

SA 4/15/27

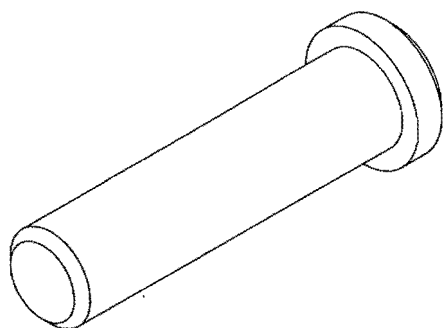
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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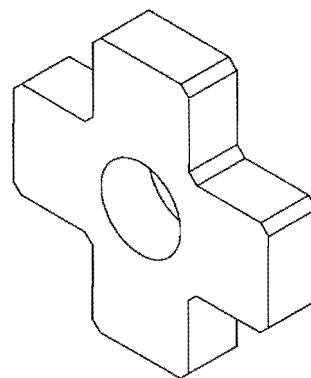
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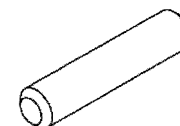


D3954-1 GWT PIN

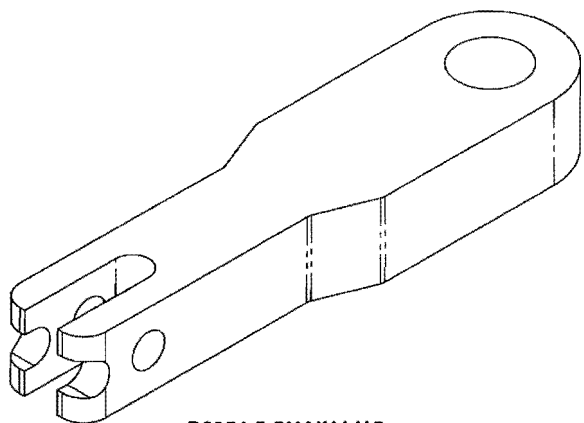


D3954-3 GWT KNOB

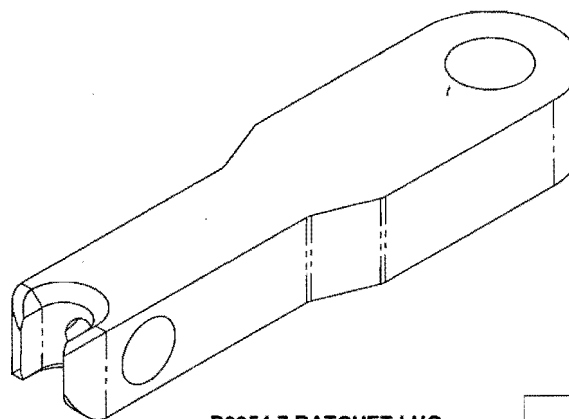
#68513



D3954-8 GWT CHAIN PIN



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

RELEASED
2009-10-19
MP

B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.		AJS	09.10.15
A	NEW ISSUE		AJS	09.05.26
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3954	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS	
DATE	09.10.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

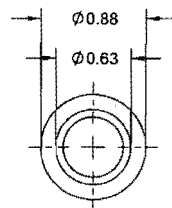
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

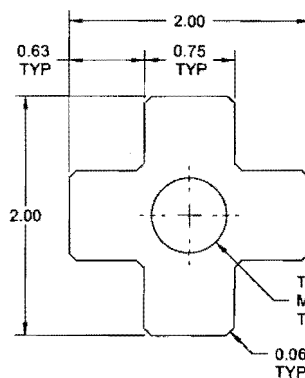
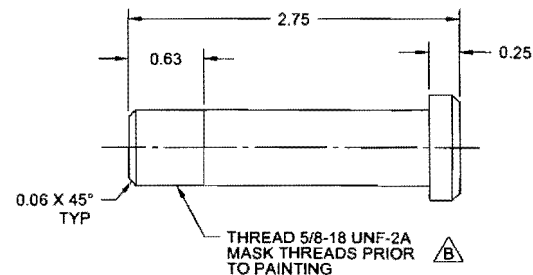
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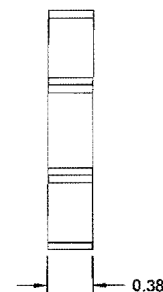
NOTE: Date & initial all entries



D3954-1 GWT PIN



D3954-3 GWT KNOB



NOTES:

1) MATERIAL -1: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

-3: AISI 1010-1025 MILD STEEL SHEET
PER DART SPEC MS1010-S

OR: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

ALTERNATE MATERIAL:

-1: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

RELEASED
2009-10-19

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3954	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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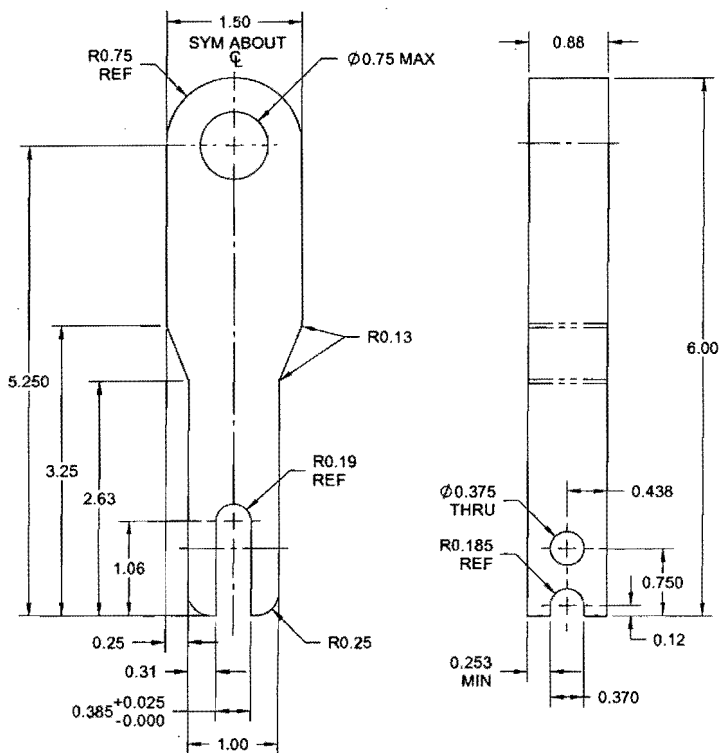
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3954-5 CHAIN LUG

NOTES:

1) MATERIAL: -5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

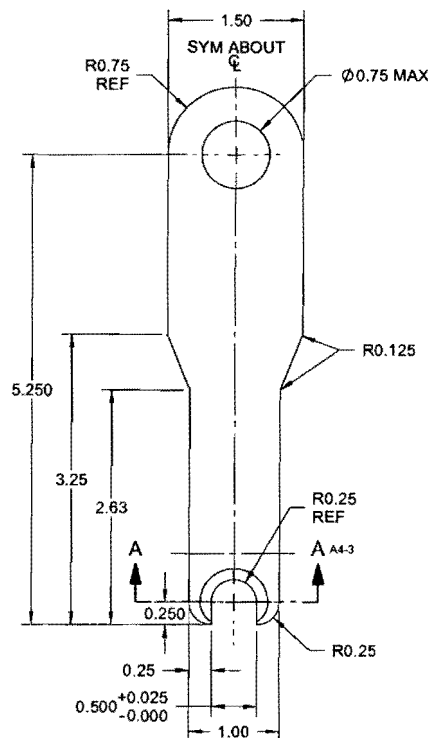
9: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

ALTERNATE MATERIAL:

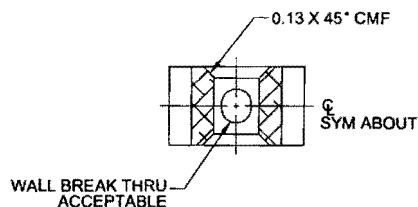
-5/-7: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

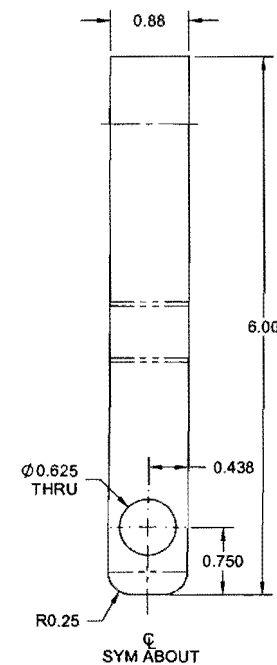
- 2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -5/-7: 1.56 lbs EACH
-9: 0.05 lbs



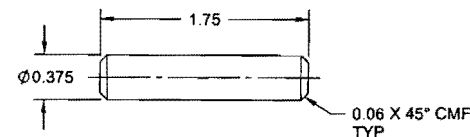
D3954-7 RATCHET LUG




SECTION A-A C3-3



D3954-9 GWT CHAIN PIN



DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3954	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT NTS	
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RELEASED
2009-10-19

#68813

W/O:		WORK ORDER CHANGES						
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